

Date: Thursday, 07/05/2009 3:30:41 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: OUTSIDE WASHER
Job Number	: 47799		
Estimate Number	: 11153		
P.O. Number	:	Part Number	: D32333 FR
This Issue	: 07/05/2009 S.O. No. :	Drawing Number	: D3233 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 47463	Material	:
Written By	:	Due Date	: 15/05/2009 Qty: 50 Um: Each
Checked & Approved By	: <u>0709-05-07</u>		
Comment	: Est. B 05.03.31 Added Powder Coat KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1020TR2000W500	1020-1025 round tubing 2.00 x .500w
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Comment: Qty.: 0.0788 f(s)/Unit Total : 3.9375 f(s)

1020-1025 Round Tube

Material: AISI 1020-1025 Seamless Tubing 2" x 0.500" wall
 (M1020TR2.000W.500)

Identify for D3233-3

Batch: M17015

**No more mat.*

SA 09/05/11

1.3A
SA

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL

Turn as per Folio FA518 and Dwg D3233

Deburr

SA 09/05/11

19

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 09/05/11

19

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

SA 09/05/11

19

5.0	POWDER COATING	POWDER COATING
-----	----------------	----------------



Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

M102391

19

START TIME: 2:10

OVEN TEMPERATURE: 320°

FINISH TIME: 2:40

BK 09-05-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 07/05/2009 3:30:41 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OUTSIDE WASHER

Job Number: 47799

Part Number: D32333

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-05-13

(X19)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: _____

CARL

09/05/13

(19)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/13

Job Completion



MF 09-05-13

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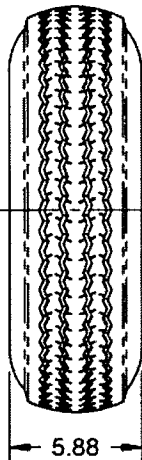
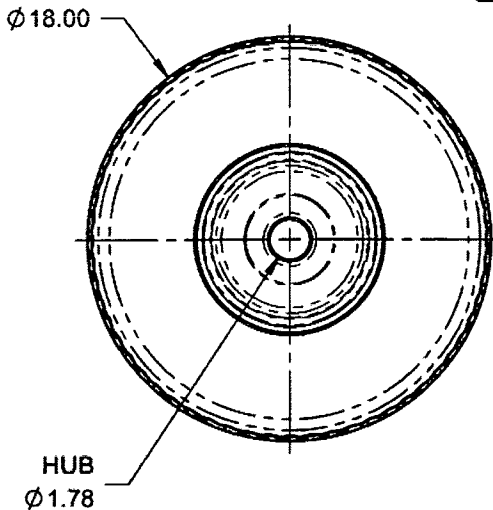
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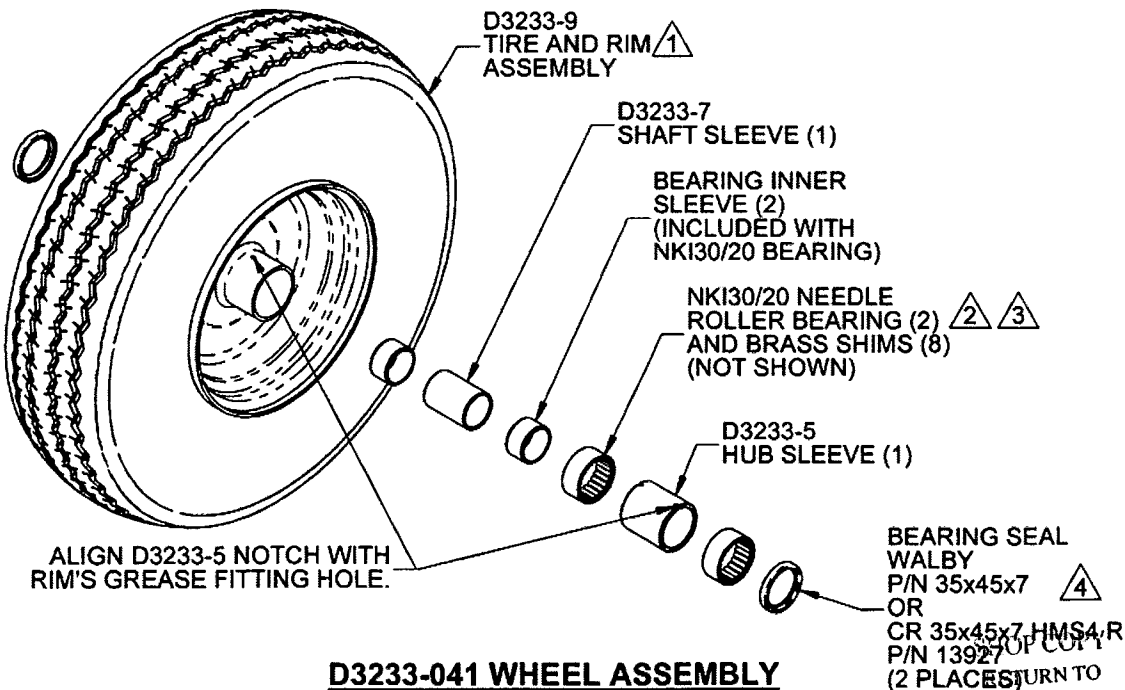
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3233	REV. B SHEET 1 OF 3
DATE 05.03.08		TITLE WHEEL ASSEMBLY	SCALE 1:1
A	05.02.18	NEW ISSUE	
B	05.03.08	ADDED BEARING SEALS	

**RELEASED**
[Signature]
05/05/04

WHEEL SPECIFICATIONS		
SIZE	MAXIMUM LOAD	MAXIMUM INFLATION LOAD
TIRE: 19.0 x 5.8 RIM: 5.70 x 8.0	910 LBS (RANGE C)	90 PSI*

* MANUFACTURER'S RECOMENDATIONS
ARE 75 PSI FOR HIGH SPEED USE.

**D3233-041 WHEEL ASSEMBLY****NOTES:**

- 1) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 8353T74
- 2) POSSIBLE SUPPLIER: GENERAL BEARING
- 3) PRESS FIT NEEDLE ROLLER BEARINGS INTO RIM HUB WITH (4) 0.5 X 0.75 X 0.004 BRASS SHIMS PER BEARING, (1) AT EACH QUADRANT
- 4) POSSIBLE SUPPLIER: GENERAL BEARING
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

BEARING SEAL
WALBY
P/N 35x45x7 **4**
OR
CR 35x45x7 HMS4-R
P/N 13927
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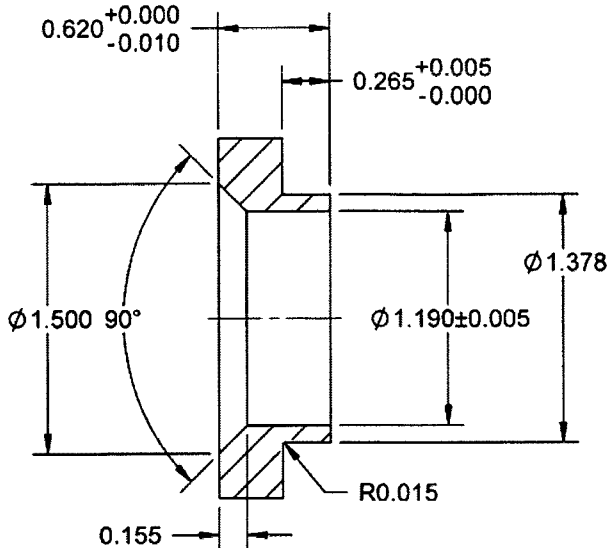
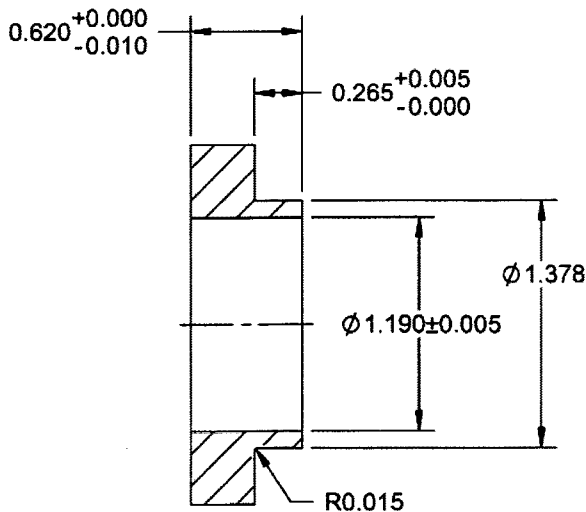
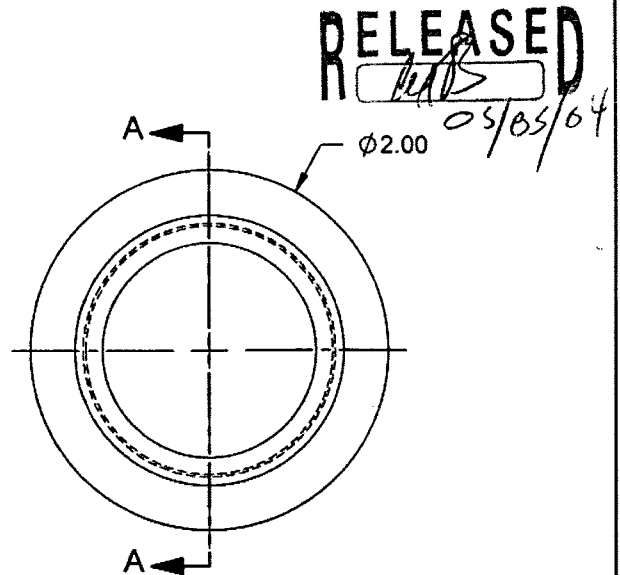
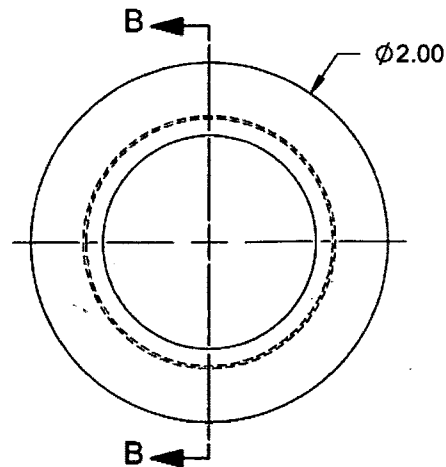
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3233	REV. B SHEET 2 OF 3
DATE 05.03.08		TITLE WHEEL ASSEMBLY	SCALE 1:1

**SECTION A-A****D3233-1 INSIDE WASHER****SECTION B-B****D3233-3 OUTSIDE WASHER****NOTES:**

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513, MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS (REF. DART SPEC. M1020TR)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

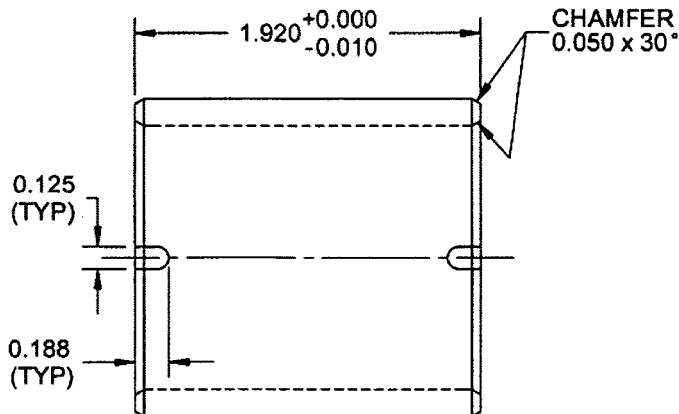
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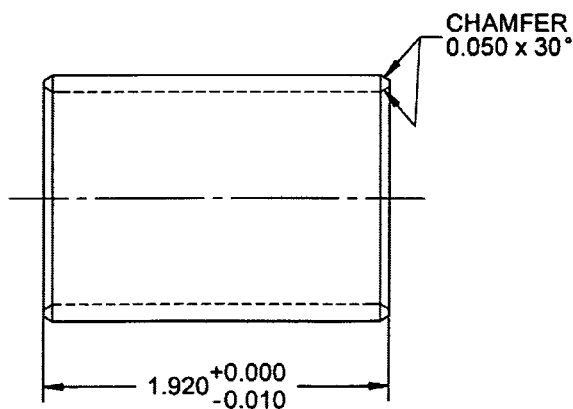
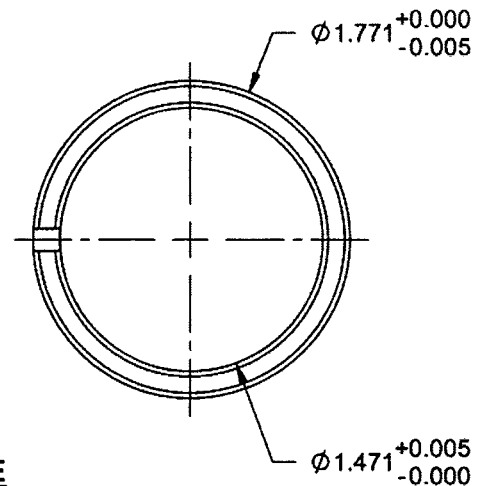


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DATE 05.03.08		TITLE WHEEL ASSEMBLY	SCALE 1:1

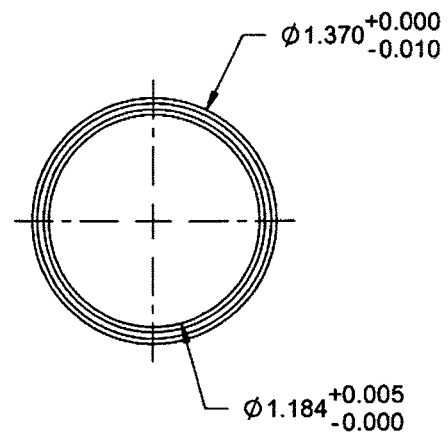
RELEASED
[Signature]
05/05/09



D3233-5 HUB SLEEVE



D3233-7 SHAFT SLEEVE



NOTES:

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS (REF. DART SPEC. M1020TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.030

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